Work Orde Tuesday, Septem												Page
Revision ID:	D3912-3 Eyebolt Block		A	Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	9/7/2010 9/13/2010	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item I Customer:	D:						
Approvals:	Process Plan	n:	Date:/ <i>6</i> -9-08 Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr			7			<del></del>				
D3912	В	Av.		•								
00  Bandsaw easpa Bandsaw		Cut blanks as per folio  Memo  CUT BLAN	K 2.50" LONG	0.00 0.00	10/09/24		(	12				

110 HAAS 1

Memo

0.00

0.00

HAAS CNC vertical machine #1

DEBURR

MACHINE AS PER FOLIO FA870 AND DWG FOLIO REV: A A DWG REV: B

W/O:			WORK ORDER CHAI	ORK ORDER CHANGES						
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					•	_				
	1				3					
Part No	): <u>D3912-3</u>	PAR #:	Fault Category: Machiniy	NCR Yes	No DQ	A:	∠ Date: ∠	0/09/30		
	Resolu	tion: <u>Scvap</u>	Disposition: Svv	QA: N/C	Closed:	75	Date: <u>/</u>	0/09/30		

NCR: 6	1835	WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B  Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approva QC inspecto				
0/6/128 110		I part popped out of vice while formy on and off -corner change all enouts on Price mile to HAD no proble	psiur	1 - SCRAPT REPlace Qty d.		29 a · 29	Posiuiz	Soloriza				
		R.C. Process: Tool polled up pm	+									

#### Work Order ID 61835

Tuesday, September 07, 2010 3:16:32 PM



Page 2

Item ID:

D3912-3

Accept



Setup Start

Run

Accept

Qty



**Revision ID:** 

**Item Name:** Eyebolt Block

Required Date: 9/13/2010

**Start Date:** 

9/7/2010

**Start Qty: 12.00** 

Req'd Qty: 12.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Code

Start

Stop



QC:

Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

Tool ID

Date:

Tool # Plan

Stop

Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID** 

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

0.00

**Run Hours** 

10/09/29

0.00

130

QC

QC8- Inspect parts - second check

Memo

0.00

Memo

Quality Control

160

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<del> </del>		F10d Mgi	
			·						
							<u> </u>		
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	Date:			
	Re	esolution:						Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	<b>R</b> )			
DATE	STEP	Description of NC	Corrective Action Section B				cation	Approval	Approval
J.(, )	0.2.	Section A	Initial Action Description Chief Eng Chief Eng		Sign 8 Date			Chief Eng	QC Inspector
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	1	1	1		Į.	1			1

#### Work Order ID 61835

Page 3

Tuesday, September 07, 2010 3:16:32 PM

Item ID:

D3912-3

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

**Item Name:** 

Eyebolt Block

9/7/2010

**Start Qty: 12.00** 

Operation

Description

Req'd Qty: 12.00

QC21- Final Inspection - Work Order Release

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Tooling:

Date:

Run

Start



Required Date: 9/13/2010

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/

**Work Center ID** 

170

Memo

Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Qty

Insp.

Number Stamp

Quality Control

0.00

0.00

Dart Aeı	rospace	Ltd								,
W/O:			W	ORK ORDER CHANGE	S					
DATE	STEP	PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		3-17				_	· · · · · · · · · · · · · · · · · · ·			
v										
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Ye	es N	o DQA	۸:	_ Date: _	
	R	esolution:	Dispositi	ion:	QA: N/C	Clos	ed:		Date:	
NCR:		W	ORK ORI	DER NON-CONFORMA	NCE (N	CR)				
		Description of NC		Corrective Action Section B				ation	Approval	Approval
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng			n & ate	Section		Chief Eng	QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng					
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								!				

### **Picklist Print**

Tuesday, September 07, 2010 3:16:38 PM

Work Order ID: 61835

Parent Item: D3912-3

Parent Item Name: Eyebolt Block



**Start Date:** 9/7/2010

Required Date: 9/13/2010

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	13.2292	0.208	2.62736 >L /	8  2/09/24	4	
				T4'		_	04						

<b>Location</b>	Loc Qty	Loc Code	
MAT	12		
115555	12		
MAT53	1.22922		
113341	0.00026		2.63
113719	1.22896		

W/O:			W	ORK ORDER CHANGI	ES			
DATE	STEP	PRC	OCEDURE CHA	ANGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		, <u> </u>					1100 11191	
•								
Part No	•	PAR #:		egory:	NCR: Yes	lo DQA:_	Date: _	
	R	esolution:	Disposition	on:	QA: N/C Clo	sed:	Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Corrective Action			verificati			Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
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<u> </u>			· .	- / - / - / - / - / - / - / - / - / - /				

DART AEROSPACE LTD	Work Order:	61835
Description: Eyebolt Block	Part Number:	D3912-3
Inspection Dwg: D3912 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.30	+/-0.030	2.300			NP(h )1-3	
Ø0.129	+0.005/-0.001	129				
0.50 Ref	+/-0.030	495			^	***************************************
R0.13	+/-0.030	. 13			R-G	
0.500	+/-0.010	500			NPINJL-3	
R0.125	+/-0.010	1.125			R-G	
0.63	+/-0.030	.628			vein 21-3	
0.750	+0.000/-0.020	137				
0.38	+/-0.030	378			Λ.	
1.500	+/-0.010	1.500	<b>/</b> /		۸.	
0.500 Pitch	+/-0.010	.500			~	
0.800	+0.000/-0.010	,498				
0.400	+/-0.010	-461				
0.516	+0.015/-0.000	:51+			~	
1.00	+/-0.030	1.990			`~	
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Measured by:	ماد	Audited by:	Preliminary Approval:	
Date:	10/09/28	Date: 6 9. 29	Date:	

	_			
Rev	Date	Change	Revised by ∧	Approved
Α	10.06.07	New Issue	KJ Q	M
	<del></del>			•

W/O:	•		\\/	ORK ORDER CHANG	EG			· ·	
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	CR:		Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date:	1
	R	esolution:	Disposition	on:	_ QA: N/C C	losed:		Date:	
NCR:		V	VORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B					cation Approval	Approval
	0.0.	Section A	Initial Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

SHOP COPY 5 RETURNIO ENGINEERING ITEM P/N DESCRIPTION D3913-041 UNCONTROLLED COPY LONG BASKET BASE ASSY (350) SUBJECT TO AMENDMENT D3913-101 TUBULAR ASSY (350 SHORT BASKET) 2 D3913-15 WIDE HANDLE PLATE WITHOUT NUMBER D2581 MOUNTING BRACKET WORK ORDER NO. 41835 BS10-9-06 4 D2931 BUMPER D4016-1 HINGE HALF, BASE D4020-1 MESH (350 BASKET LONG BASE) END MESH, BASKET D4020-11 8 D4021-1 HANDLE PLATE D4021-5 BLANKING PLATE 10 AN3-10A BOLT 11 AN960JD8 WASHER 10 14 14 13 MS20600AD4W3 BLIND RIVET 13 MS21042L3 NUT 12 NAS1149F0332P WASHER С (4)(11)(12)13 14 14 10 **D3913-041 LONG BASKET BASE ASSY (350)** (MESH SHOWN LOCALLY FOR CLARITY) NEW ISSUE Α 10.03.16 NOTES: 1) MATERIAL: N/A REV. DESCRIPTION BY DATE 1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 43.3 lbs APPROX
8) INSTALL AFTER FINISH
9) MASK HOLES PRIOR TO POWDER COAT DESIGN DART AEROSPACE LTD DRAWN

9) MASK HOLES PRIOR TO POWDER COAT

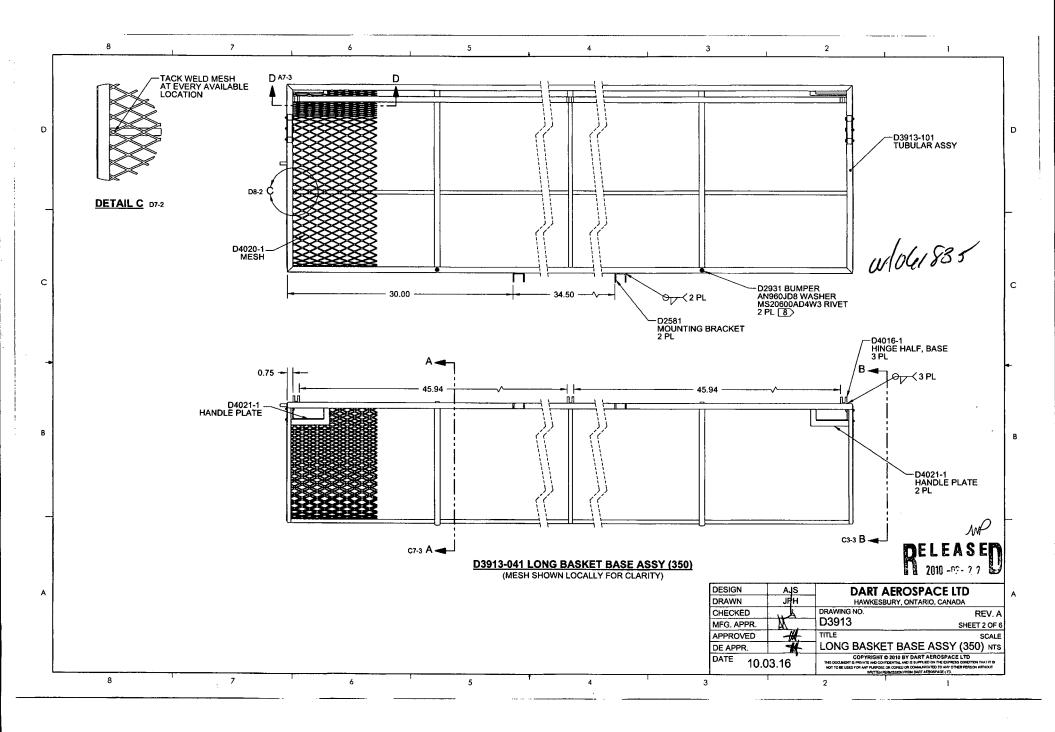
10) WELD PER DART QSI 004

HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3913 MFG. APPR SHEET 1 OF 6 TITLE APPROVED LONG BASKET BASE ASSY (350) NTS DE APPR. DATE

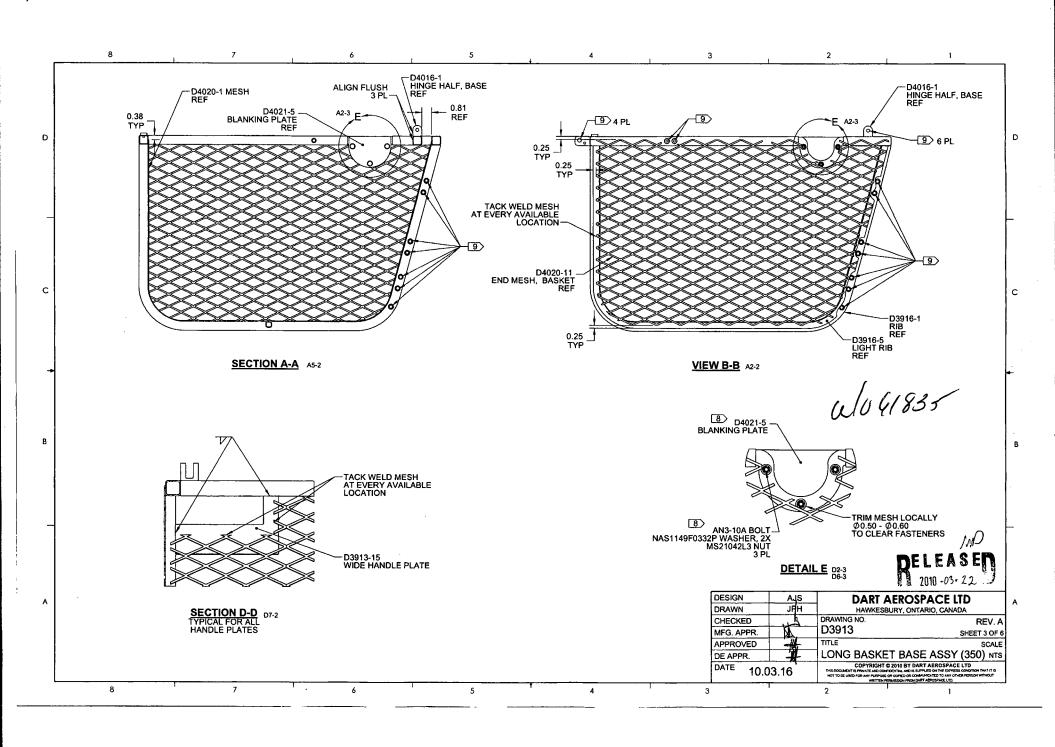
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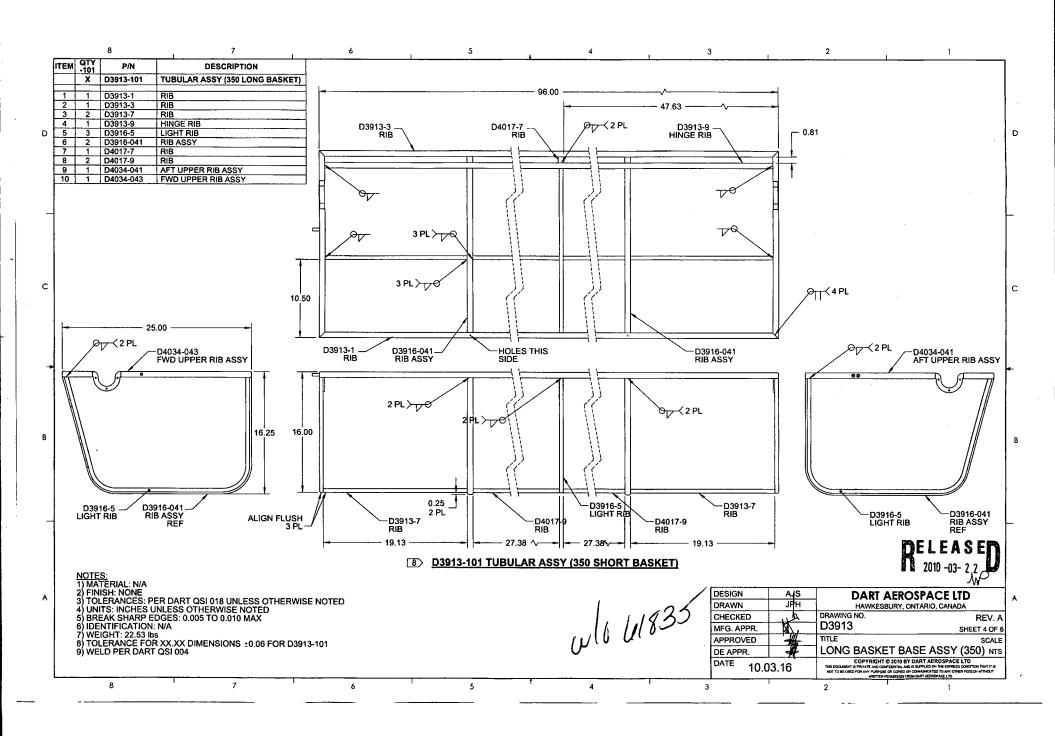
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				Fault Category: NCR: Yes No DQA: Disposition: QA: N/C Closed:						
	n							Date: _		
NCR:			WORK OR	DER NON-CONFORMA	INCE (NCF	ኅ <i>)</i> 		<b>,</b>	_	
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector	
,			Chief Eng	Chief Eng	Date					
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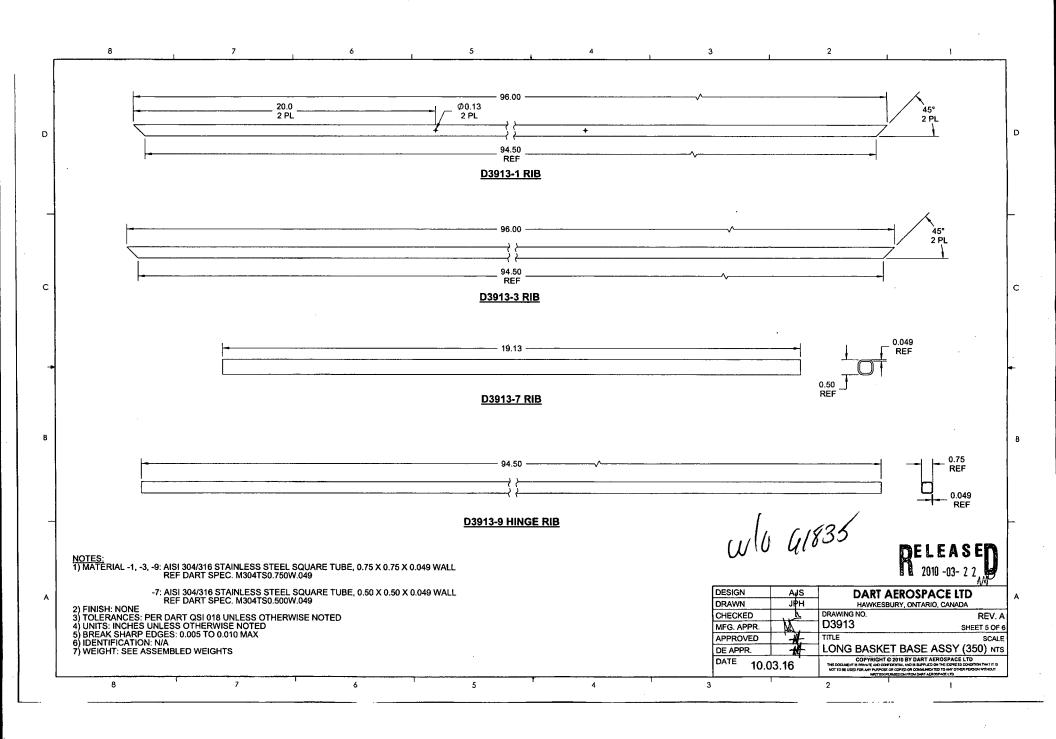
W/O:			V	ORK ORDER CHANG	ES				
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						<del>-</del>			
Part No	·	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposit	ion:	_ QA: N/C CI	osed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Corrective Action			on B	Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Section C	Chief Eng	QC Inspector
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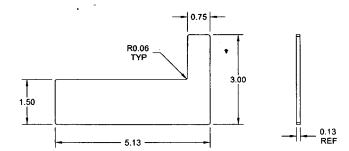
	12											
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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DATE STEP PROCEDURE CHANGE By	s No DQ	A:	Date: _									
	R	esolution:	Disposit	ion:	QA: N/C	Closed:		Date: _				
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (NO	CR)						
DATE	STED	Description of NC	Description of NC		Verific			ion Approval	Approval			
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W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
								Prod Mgr	
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQA</b> :		_ Date: _	
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האדר	CTED	Description of NC Corrective Action Section				Verifica	tion	Approval	Approval
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Part No	) <b>:</b>	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	<b>\</b> :	_ Date: _		
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NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)				
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	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Section C	Chief Eng	QC Inspector	
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**D3913-15 WIDE HANDLE PLATE** 

W/ 61835

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

8

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8

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED	,,	DRAWING NO. REV. A					
MFG. APPR.	M.	D3913 SHEET 6 OF 6					
APPROVED	4	TITLE SCALE					
DE APPR.	4#	LONG BASKET BASE ASSY (350) NTS					
DATE 10.0	3.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOOLMENT BY PRIVATE AND COMPENSION, AND BY EXPPLED ON THE EXPRESS COMPITTION THAT IT IS NOT TO BE USED FOR ANY PRIPAGES OR COMPANIENTED TO ANY OTHER PERSON WITHOUT					

Dart Ae	rospace	e Ltd							<b></b>
W/O:			V	VORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No				tegory:N					
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NCR:		W	ORK OR	DER NON-CONFORMANO	CE (NCF	R)			
		Description of NC	Corrective Action Section B		n B Verificat		cation	Approval	Annual
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	& Sect	ion C	Chief Eng	Approval QC Inspector
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0.800+0.000 Ø0.129 THRU 1.500 4 PL 0.38 0.400 0.500 PITCH 0.50 REF 1.00 0.750 +0.000 0.500 R0.13 R0.125 0.516+0.015 0.63

#### **D3912-3 EYEBOLT BLOCK**

1..500 0.500 PITCH \_∆0.375\ R0.13 TYP 0.38 0.25 0.517 1.000 1.500+0.020 2.00 REF Ø0.129  $\phi$ 0.257 8 PL 0.125 2 PL REF 3.65 3.69 REF

#### **D3912-5 EYEBOLT PLATE**

ant and

DESIGN	455	DART AEROSPACE LTD	-
DRAWN	18	HAWKESBURY, ONTARIO, CANADA	
CHECKED	_40	DRAWING NO. RE	V. B
MFG. APPR.	all	D3912 SHEET 3	OF 3
APPROVED	149	TITLE SC	ALE
DE APPR.	-4	EYEBOLT RECEIVER ASSY	NTS
DATE 10.0	6.28	THIS DOCUMENT OF PRIVATE AND COMPORTHING AND IS SUPPLIED ON THE GOVERNMENT OF THE PRIVATE AND COMPORTHING AND IS SUPPLIED ON THE GOVERNMENT OF THE PRIVATE AND COMPONENT OF THE PRIVATE AND CO	

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

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D,

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

8

2